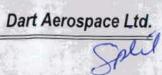
Process Sheet



Job Number	: CU-DAR001 Dart Helicop : 44079 -	ters Services	Drawing Name	: SADDLE ASSEMBLY	
Estimate Number	: 11180				
P.O. Number	: 75.15		Part Number	: D2282043	
This Issue	: 15/12/2008 S.O. No.	1	Drawing Number	: D2282 REV E	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: // Type	: LARGE FAB ASSY	Drawing Revision	: E	
Previous Run	: 43556B		Material		19
			Due Date	: 22/12/2008 Qt	y: 29 Um: Each
Written By	ad Du	11/			- Company
Checked & Approv		Annual trans O Diet	E 12.02 II M		
	: Est Rev:A	Removed from 9 Digit 0	5-12-02 JLM	(1)	10.1
Additional Product	, a ====	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1			
Job Number:		To the second			
Seq. #:	Machine Or Operation:		Description :	7	¥
1.0	D2281	Jack	Saddle	A ==:	
		- 4 × 1		A	1
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22,7111	Pick:	2) Old . 20.0000	Lucinio		THE PERSON NAMED IN
	Qty Part Number	Description Batch			
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	1 D2281 Sado	TOTALL		17.7	7 -
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F.s		20	Via.	EL 8	-12-19 XOI
2.0	D22827	Tube	N. A.	X	
		a file		M.	10 10 15
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	Pick:	44.9491			
	Qty Part Number	Description Batch	7	17 3 4	
	2 D2282-7	tube B41891	1 1	n de	2-19 X58
3.0	LARGE FAB 1		CE EADDICATION DECOURS	El. 81	MCX XXX
3.0	S [[[[]]]]]	LAR	GE FABRICATION RESOURCE		
1		1.5			199
Comn	nent: LARGE FABRICATION	N RESOURCE 1	1		
	1-Weld as per D2282-	043 Saddle Assembly			
	A/R ER316L SS	Filling Rod MIO7	057	K A	
	1	Dwg Rev:	1.5	EL 8-	1) 19 179
4.0	SMALL FAB 1		ALL & MEDIUM FAB RESOUR		0-11 10-1
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-5.7%3.8%					5 · · ·
3 10 10					
Comn	nent: SMALL & MEDIUM FA			1	
3 S S S	1- grind weld flush, tal	ce all welding markes out a	and deburr holes	PL 8	12-22 X29
1 1				Notice and Leading	44 47 1

Dart Aerospace Ltd

W/O:			WORK ORDER C	HANGES					
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DATE	STEP	Description of NC Section A	Initial Action Desc	cription	Sign	OCCI		Approval Chief Eng	Approval QC Inspector

2		Description of NC	4	Corrective Action Section	В	Vavification	A	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Monday, 15/12/2008 10:10:25 AM User: Linda Lacelle **Process Sheet** Drawing Name: SADDLE ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Job Number: 44079 Part Number: D2282043 Job Number: Seq. #: Machine Or Operation: Description: 5.0 QC9 VISUAL WELDING INSPECTION Comment: VISUAL WELDING INSPECTION 6.0 QC5 06.12.23 Comment: INSPECT WORK TO CURRENT STEP 7.0 SMALL FAB SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-tumble 8.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 9.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: C-A 10.0 FINAL INSPECTION/W/O RELE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

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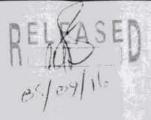
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DATE	STEP	PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Category:			No DQ		_ Date: _	
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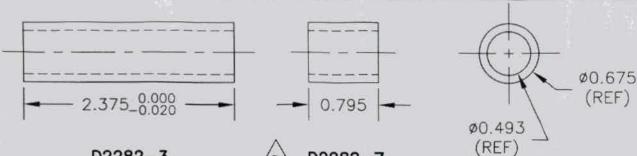
NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
		Description of NC	Corrective Action Section		В	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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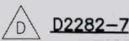
DESIGN BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. E D2282 SHEET 1 DF 2
DATE 05.06.07		TITLE SCALE HANDLE TUBES 1:1
A	94.10.14	NEW ISSUE
В	95.03.23	RE-DESIGN
С	97.10.20	CORRECTED NUMBERING SCHEME
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030

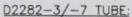
(REF)





D2282-3





- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

R0.063 x 0.063 DEEP 4 0.090 x 45° 0.95 -CHAMFER 0.158 -Ø0.700 R0.350 -Ø0.386 0.1250.080 x 45° (REF) CHAMFER

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

2.17

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D2282-5

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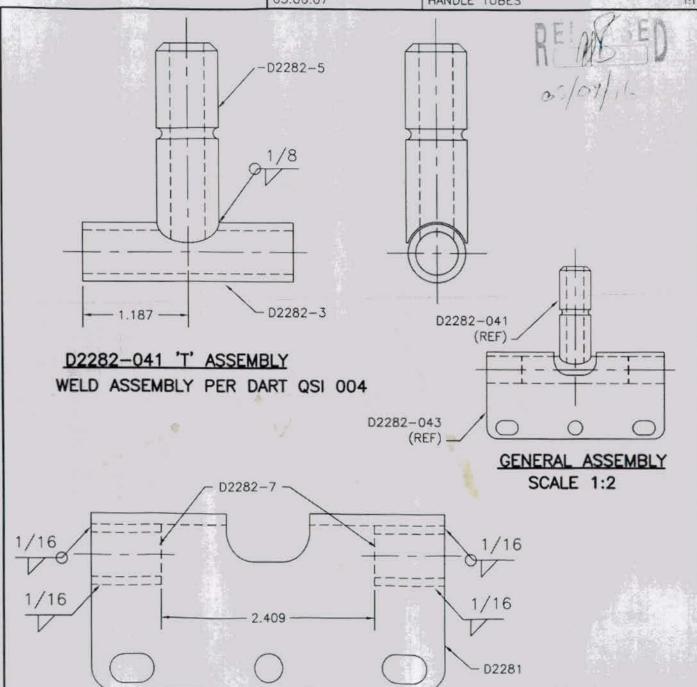
W/O:			WORK ORDER CI	HANGES					
DATE	STEP	PRO	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Part No	Resolution:	PAR #:	Fault Category:	W-2 6 12 9 6	R: Yes	No DQ	A:	Date: _	

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		Description of NC		Corrective Action Section	В	Verification	Approval	Approval
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CHECKED	APPROVED	DRAWING NO. D2282	REV. E SHEET 2 OF 2
05.06.07	T WAY	HANDLE TUBES	SCALE 1:1



D2282-043 SADDLE ASSEMBLY WELD ASSEMBLY PER DART QSI 004

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES	734-1				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	*						

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:	Disposition:	QA: N/C Closed:	Date:

		D. J. W. ANG	Corrective Action Section B			Varification		Aki Jer	
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